


17/09

Date: Tuesday, 9/11/2007 10:56:50 AM
User: Chantal Lavoie

Process Sheet

Customer :	Drawing Name : DOUBLER	
Job Number : 34545		
Estimate Number : 12959		
P.O. Number :	Part Number : D36421	
This Issue : 9/11/2007 S.O. No. :	Drawing Number : D3642 UNDER REVIEW	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / /	Drawing Revision : U/R	
Previous Run : 33721	Material :	
Written By : <u>W</u>	Due Date : 9/18/2007	Qty: 4 Um: Each
Checked & Approved By : <u>W</u>		
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By:EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.1747 sf(s)/Unit Total: 0.6989 sf(s)

2024-T3 .050 sheet

Batch: M105646

HB 07-09-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3642

Dwg Rev: A

Prog Rev: A

HB 07-09-19

(4)

2-Deburr if necessary HB 07-09-19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-09-19

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

HB 07-09-19

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HB 07-09-20

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:56:50 AM
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Process Sheet

Customer:

Drawing Name: DOUBLER

Job Number: 34545

Part Number: D36421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 2/08/20 (40)

7.0

PACKAGING 1.

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

ENGINEERING
APPROVAL

07.10.15

Fluor 15 (4x) 54

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.16 HJ

Job Completion



U 07-10-16

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE 07-10-16

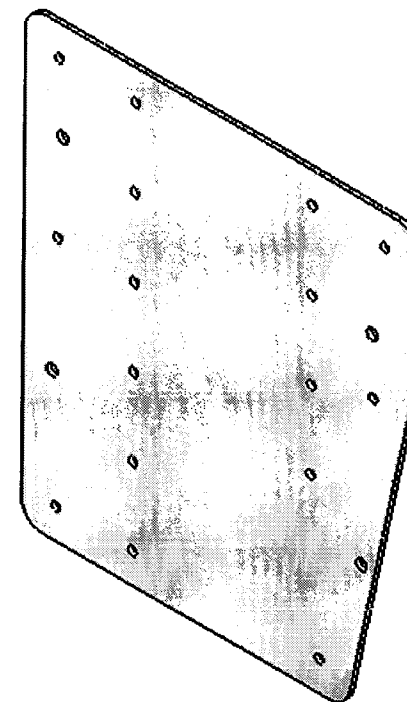
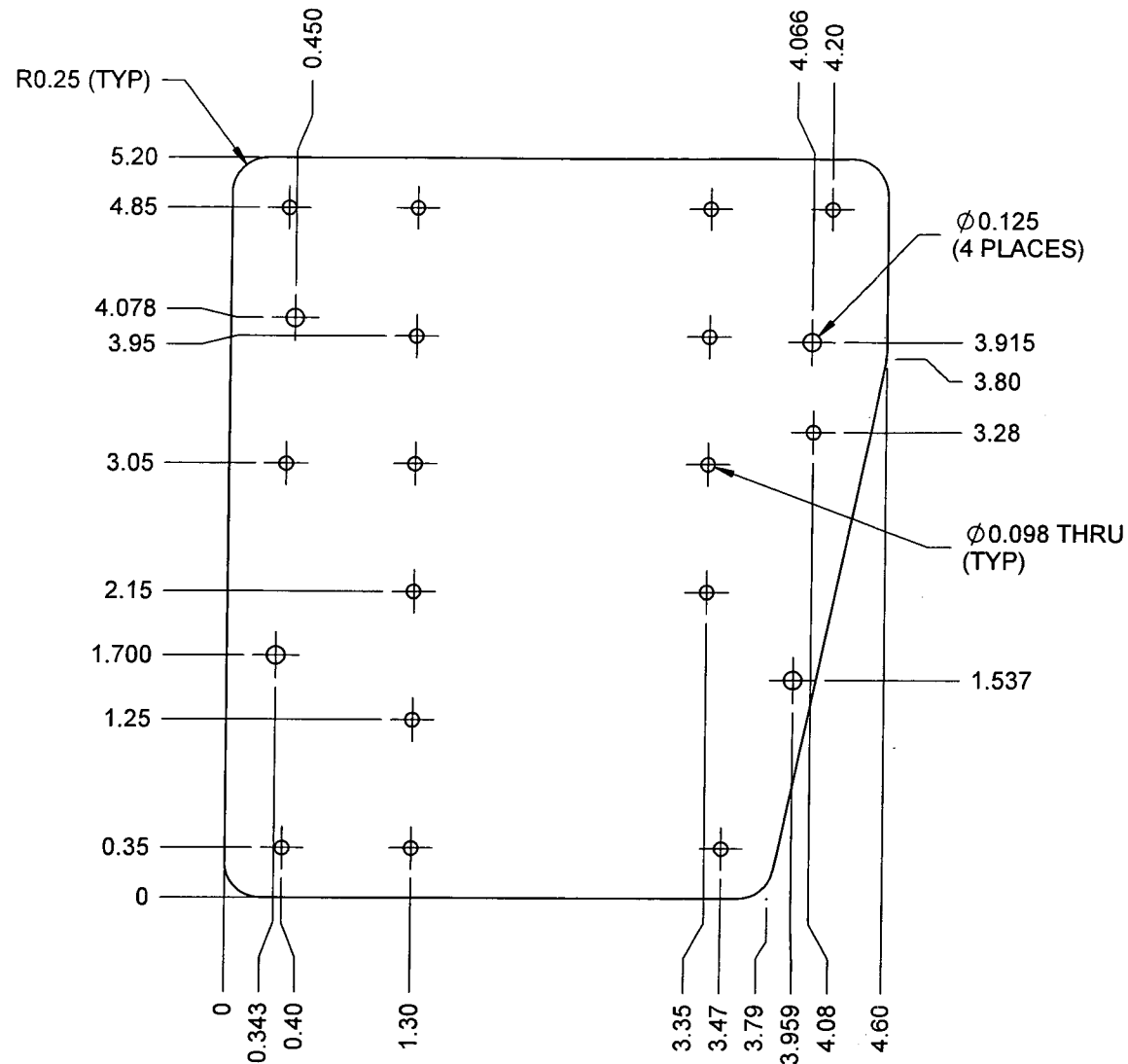
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W034545 24/24

D3642-1 DOUBLER (WAS GENEVA P/N G10607-1)
D3642-2 OPPOSITE (WAS GENEVA P/N G10607-2)

PRELIMINARY ISSUE

07-09-07 16

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

A	NEW ISSUE; REPLACES G10607		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.		
DRAWN	LE	PORT HADLOCK, WA		
CHECKED	TS	DRAWING NO.	REV. A	
MFG. APPR.	TS	D3642	SHEET 1 OF 1	
APPROVED	TS	TITLE	SCALE	
DE APPR.		DOUBLER	4:	
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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DART AEROSPACE LTD		Work Order: 34545
Description: DOUBLER		Part Number: D3642-1
Inspection Dwg: D3642 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

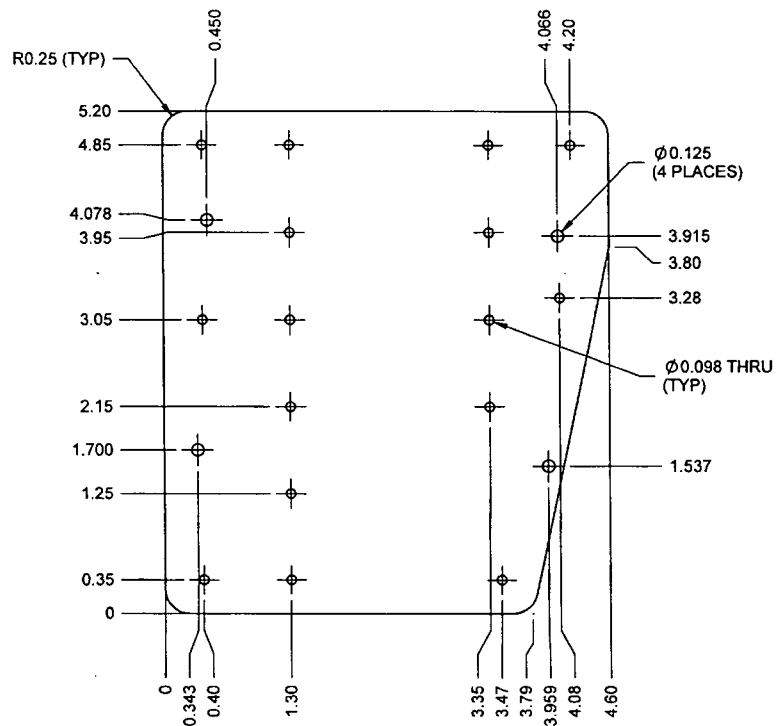
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .125	+ .005 - .001	.125				
Ø .098	+ .004 - .001	.98				
5.20	+/- .030	5.20				
4.85	+/- .030	4.85				
4.078	+/- .010	4.078				
3.95	+/- .030	3.95				
3.05	+/- .030	3.05				
2.15	+/- .030	2.15				
1.700	+/- .010	1.700				
1.25	+/- .030	1.25				
.35	+/- .030	.35				
.450	+/- .010	.450				
.343	+/- .010	.343				
.40	+/- .030	.40				
1.30	+/- .030	1.30				
3.35	+/- .030	3.35				
3.47	+/- .030	3.47				
3.79	+/- .030	3.79				
3.959	+/- .010	3.959				
4.08	+/- .030	4.08				
4.60	+/- .030	4.60				
4.066	+/- .010	4.066				
4.20	+/- .030	4.20				

Measured by: EB	Audited by: EN	Prototype Approval: KE
Date: 07-09-19	Date: 07/09/19	Date: 07.09.19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

REFERENCE ONLY



D3642-1 DOUBLER (WAS GENEVA P/N G10607-1)
D3642-2 OPPOSITE (WAS GENEVA P/N G10607-2)

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RELEASED
 07 29 27

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DRAWN	LE	PORT HADLOCK, WA	
CHECKED	TS	DRAWING NO.	REV. A
MFG. APPR.	TS	D3642	SHEET 1 OF 1
APPROVED	TS	TITLE	SCALE
DE APPR.	TS	DOUBLER	4:5
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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